

Work Order ID 50063

July 7, 2009 1:21:20 PM



Page 1

Item ID: D3929-041
Revision ID: A
Item Name: Gusset Assembly

Accept



Setup Start



Stop



Start Date: 7/08/09 Start Qty: 6.00
Required Date: 7/15/09 Req'd Qty: 6.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

100

0.00



Waterjet
FLOW CNC Waterjet

Memo
1-Cut as per Dwg D3929
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary

0.00

⇒ ml 09 07 13 (6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC
Quality Control

Memo

0.00

⇒ ml 09.07.13 (6)

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Setup Start



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Stop



Item Name: Gusset Assembly

Start Date: 7/08/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 50910213 (x6)

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

PD 09-07-14

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M108160

PD 09-07-14 (6)

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Setup Start



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Item Name: Gusset Assembly

Start Date: 7/08/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

CP 09.07.14

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 09/07/14 (x6)

f

170

Identify as per dwg & Stock Location:

Basket

0.00



Packaging

Memo

0.00

Packaging

AD 09.07.14 (6)

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Item ID: D3929-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gusset Assembly

Start Date: 7/08/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/07/15 *[Signature]*

MF 09-07-15

Picklist Print

July 7, 2009 1:21:19 PM

Work Order ID: 50063

Parent Item: D3929-041RevA

Parent Item Name: Gusset Assembly



Comments:

Start Date: 7/08/09

Required Date: 7/15/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	120.3800	2.8421 			
304/316 0.125 Sheet												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

111018

120.38

120.38

130

Each

16.0000

12.0000


ml.mt

09 07 13

D3907-1RevA

Manufactured

No



Bushing

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

48438

50517

16

16

4
8

PD 09-07-14

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

*no
good 3*

D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED
5/10/04/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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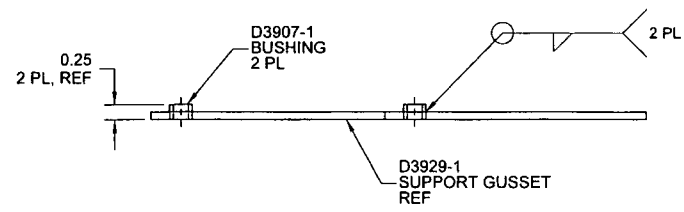
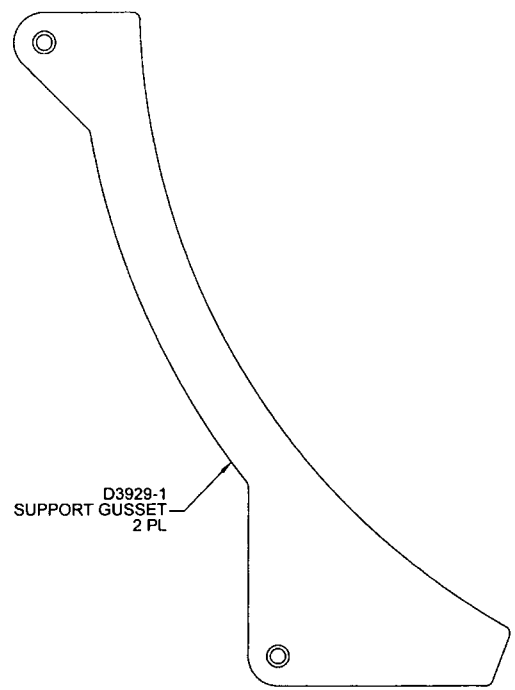
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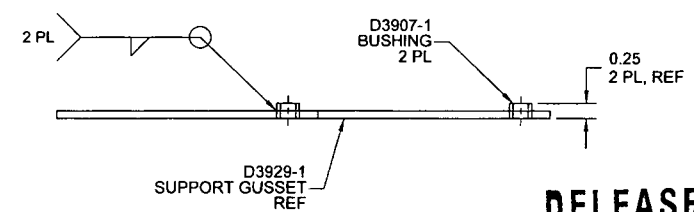
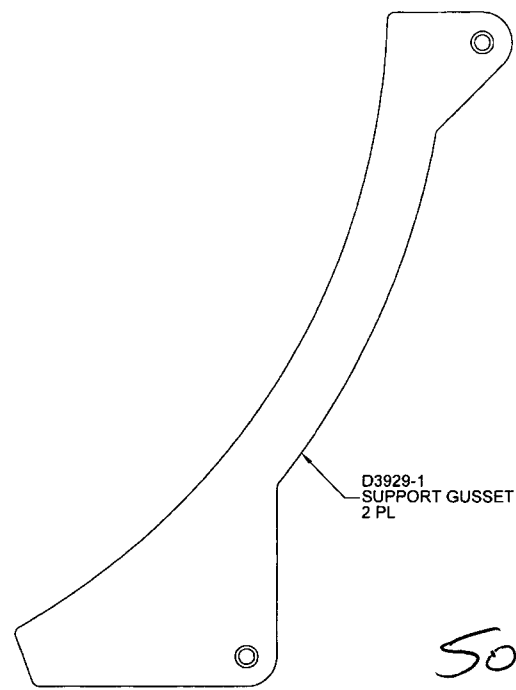
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A



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

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MFG. APPR.		TITLE	SHEET 2 OF 3
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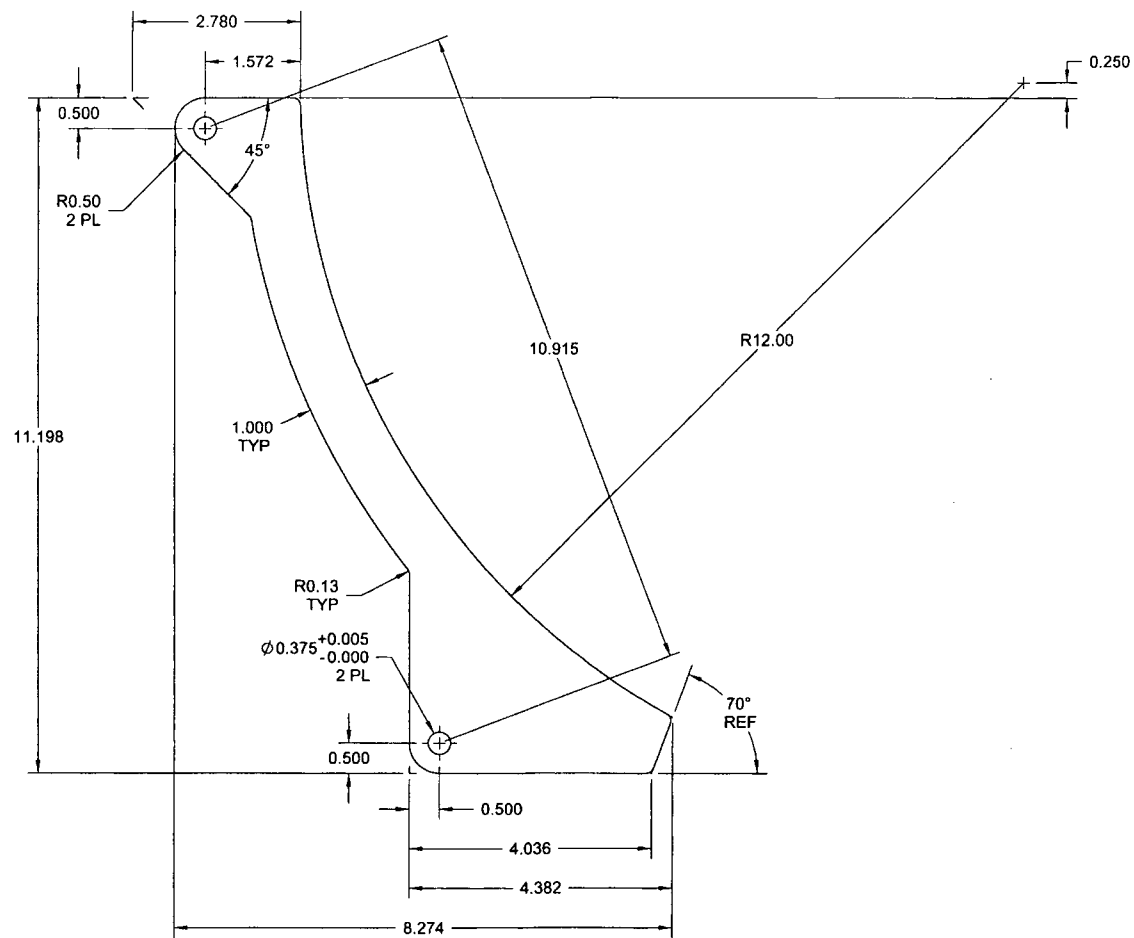
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B

A

8 7 6 5 4 3 2 1



D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

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01/04/22 JWD

50063